








Work Order ID 52374




Tuesday, September 22, 2009 3:13:55 PM



Page 2

Item ID: D3276-042 Accept  Setup Start 
Revision ID: B Stop 
Item Name: Baffle Assembly RH
Start Date: 9/23/2009 Start Qty: 6.00  Cust Item ID:
Required Date: 10/9/2009 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00							
Small Fab	Memo 1-Deburr□2-Roll as per Dwg D3276	0.00	80	09/11/19		6	0		
140  Brake NC	NC BRAKE	0.00							
Brake NC	Memo Form as per Dwg D3276	0.00	80	09/11/19		6	0		
150  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00	80	09/11/19		6	0		

Work Order ID 52374

Tuesday, September 22, 2009 3:13:55 PM



Page 4

Item ID: D3276-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: Baffle Assembly RH

Start Date: 9/23/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3276								
200 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
210 	Identify as per dwg & Stock Location: <u>175</u>	0.00							
Packaging	Memo	0.00							
Packaging									

9/30/09/27 (C)

88 09/11/26

(D)

9/16/30 (C) d

Work Order ID 52374

Tuesday, September 22, 2009 3:13:55 PM



Page 5

Item ID: D3276-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: Baffle Assembly RH

Start Date: 9/23/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/30

PS 09-11-30
(6)

Picklist Print

Tuesday, September 22, 2009 3:13:55 PM

Page 1

Work Order ID: 52374



Parent Item: D3276-042RevB



Parent Item Name: Baffle Assembly RH

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3276-3RevB Manufactured No



Decal

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

44306

9

9

190

f

807.2500

13.5000



Ep 09/11/20
B52913 (34)

3

D2464RevB

Manufactured No



3/4 Seal

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

39669

48173

807.25

101.24

706.01

Ep 09/11/20

13.5

Picklist Print

Page 2

Tuesday, September 22, 2009 3:13:55 PM

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Parent Item: D3276-042RevB



Parent Item Name: Baffle Assembly RH



Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			190	sf	114.0568	6.4453			
 												
6061-T6 .040 Sheet												

18 9-10-08

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

114.0568

100742

3.3

102723

7.93

105842

12

106747

12.5

107461

13.1642

109396

22.28

111224

41.3826

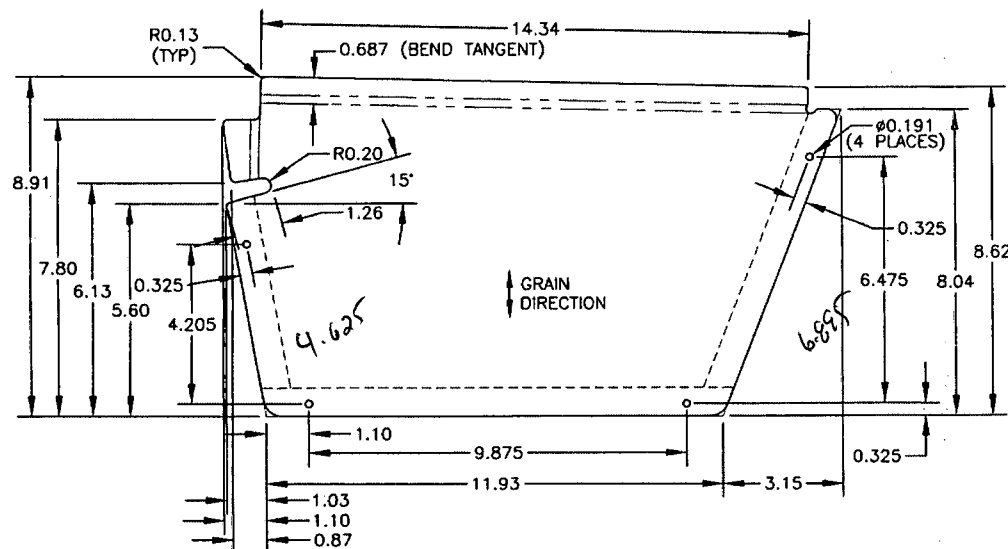
19380

1.5

113004

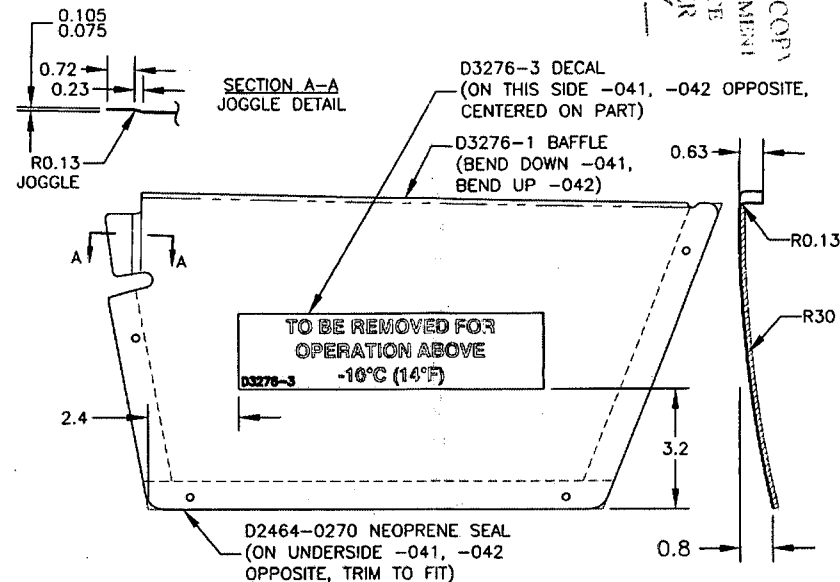
113004

SHOP COPY
RETURN TO
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SUBJECT TO AN ENDORSEMENT
WITHOUT NOTICE
WORK ORDER
NO. 52374

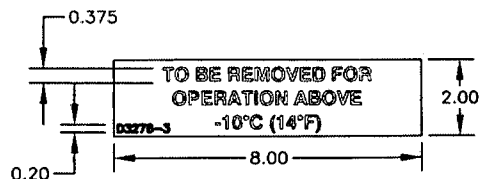


D3276-1 BAFFLE (FLAT PATTERN)

- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-041 BAFFLE ASSEMBLY, LH (SHOWN) D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)



D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7. MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.02.04

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B	05.01.25	LABEL NOW -10°C; CURVE PART	
A	05.01.07	NEW ISSUE	
DESIGN	CP	DRAWN BY	CP
CHECKED	#	APPROVED	#
DATE	05.01.25	DRAWING NO.	D3276
		TITLE	BAFFLE ASSEMBLY
		REV. B	SHEET 1 OF 1
		SCALE	1:3

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HARRISBURG, ONTARIO, CANADA